

Work Order ID 84293

84293

Wednesday, May 09, 2012 10:10:31 AM

Page 1

Today

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 5/9/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/9/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-05-09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2563	Rev C

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563
 2-Deburr ends
 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343
 4- Grind

1. 0 12-05-09

110 0.00
110 QC9- Inspect visual per QS1004- Fusion Welds
 QC Memo 0.00
 Quality Control

1. 0 12-05-09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/9/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/9/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

Solution

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0,00

130

Memo

0.00

HandFinish

Hand Finishing

140

~~QC3-~~ Inspect Part Finish

0.00

140

QC7

Memo

0.00

QC

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/05/10	#146	change to Ac7					8 12/05/10

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>119785</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig End cap as per Dwg D2563 using DT 8343 3-Grind	0.00 0.00				<u>1</u>	<u>0</u>		<u>K</u> 12.05.09
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<u>8.7.6.5.10</u>
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>8.7.6.5.10</u> <u>CC</u>

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00				1X	Ø		M-L 12/05/10
175									
HandFinish	Memo	0.00							
Hand Finishing	Touch up Alodine as per QSI005								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	Ø		M-L 12/05/10
180									
Powdercoat	Memo	0.00							
Powder Coating	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	START TIME: 10:52 OVEN TEMPERATURE: 320 01- FINISH TIME: 11:20								
190	Wing Walk as per dwg QSI005 4.4 Batch 121505	0.00				1	Ø		BK 12/05/10
190									
HandFinish	Memo	0.00							
Hand Finishing									

M, 21134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D2563

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Step Weldment Assembly

Stop ***NS2***

Start Date: 5/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

PAP 82565

1x 9 12/05/16

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/5/17

YME
12-05-16

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W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 09, 2012 10:10:30 AM

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Work Order ID: 84293

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 5/9/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			100	Each	85.5000	1	1		12.05.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		0.5							
				60307		0.5							
				WA		85							
				80803		85							
D2561 Lug		Manufactured	No			100	Each	20.0000	2	2		12.05.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		15							
				80813		15							
				WA015		5							
				66813		5							
D2564 Mounting Angle		Manufactured	No			100	Each	18.0000	2	2		12.05.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		18							
				83712		18							
D2673-34 End Plate		Manufactured	No			100	Each	32.0000	1	1		12.05.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		12							
				81468		12							
				WA015		20							
				59690		20							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 09, 2012 10:10:30 AM

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Work Order ID: 84293

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 5/9/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2673-34

Manufactured No

150 Each 32.0000

1

1

End Plate

12.05.09

Location

Loc Qty

Loc Code

WA

12

81468

12

WA015

20

59690

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

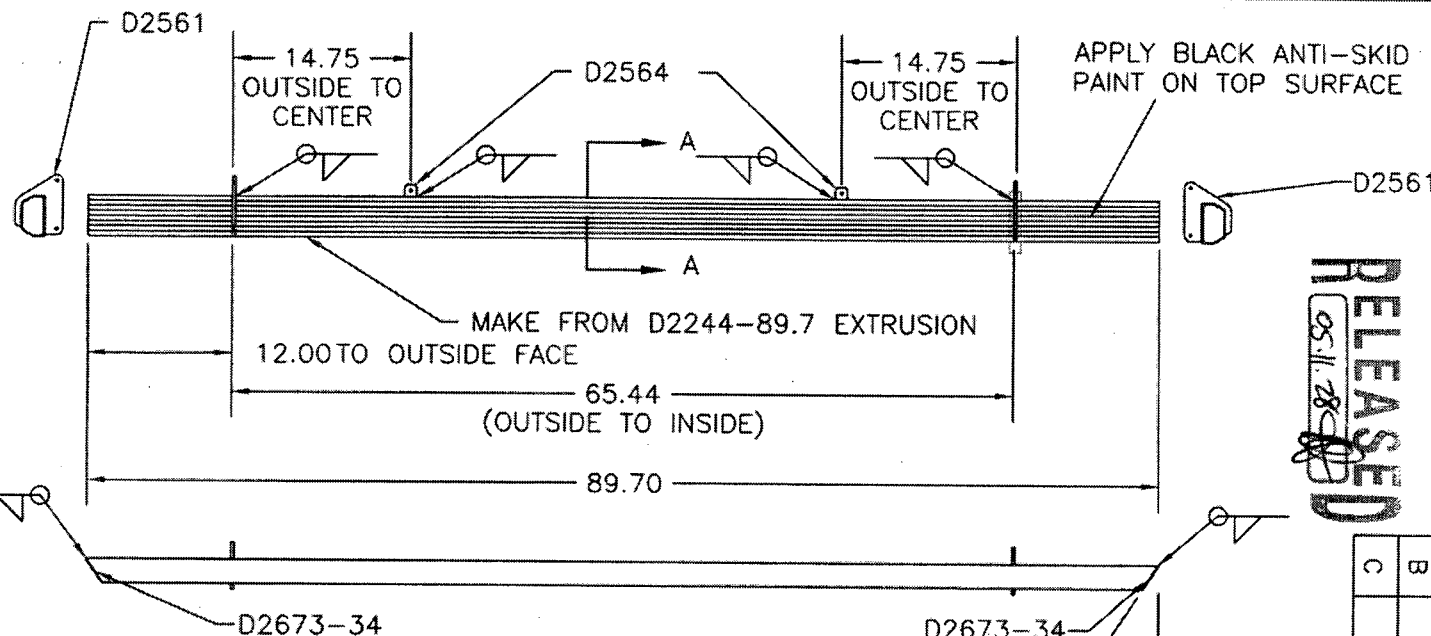
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RELEASED
05.11.28

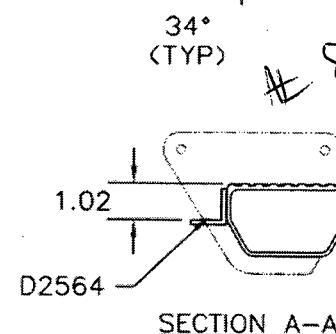
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	44	HAMMERSBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
44	44	D2563
DATE		TITLE
05.11.14		STEP WELDMENT ASSEMBLY
		SCALE
		1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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